

# Work Order ID 82007

\*82007\*

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March-21-12 3:47:15 PM

Item ID: D2894-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: 2.750 Support  
 Start Date: 21/03/2012 Start Qty: 6.00 \*6\* Cust Item ID:  
 Required Date: 27/04/2012 Req'd Qty: 6.00 \*6\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/12 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2894	E								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
*100*									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA253 Tumble & Deburr								
			PO / F.K	12/04/13		6	2		PTO
110	QC1- Inspect dimensions to dimension sheet	0.00							
*110*									
QC	Memo	0.00							
Quality Control									
			PO / F.K	12/04/13					
120	QC8- Inspect parts - second check	0.00							
*120*									
QC	Memo	0.00							
Quality Control									
			OK 12/05/13			6			

W/O: 82007		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2894-1 PAR #: \_\_\_\_\_ Fault Category: Machining NCR: (Yes) No DQA: dot Date: 12/05/23  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 4 Date: 12/5/23

NCR: 12-1436		WORK ORDER NON-CONFORMANCE (NCR) $359.12 \times 2 = 718.24$						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/19	100	hole $\phi .500$ off center .005" on first and .010" on 2nd. LL. Process	<u>LS</u> 12/04/20 QST042	Does not fit rocker beam. Scrap. P. 12.04.19	<u>FX</u> 12/05/13	<u>and</u> 12/05/13	<u>and</u> 12/04/20 QST042	<u>S</u> 12/04/24

NOTE: Date &amp; initial all entries

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Item ID: D2894-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>L652</u>	0.00							
<b>*130*</b>									
Packaging	Memo	0.00				<u>AB</u>	<u>12</u>	<u>5</u>	<u>15</u>
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

12/5/16   
 MF  
 2-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82007

\*82007\*

Parent Item: D2894-1

\*D2894-1\*

Parent Item Name: 2.750 Support

Start Date: 21/03/2012

Required Date: 27/04/2012

Start Qty: 6.00

Required Qty: 6.00

## Comments:

IPP: B02.11.26Added mask holeKJ

IPP Rev:C ECN 993 07-11-07 DD verified by:EC

IPP D 08.03.19 Re-format EC verified by DD IPP REV:E

11.10.03 ASPER REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK079		Manufactured	No			100	Each	8.0000	0.5	3			

\*DSK079\*

D2894-1 TURNING DETAIL

\*\*

F.K. 12/04/14

## Location

## Loc Qty

## Loc Code

MAT060

8

72634

2

72658

6

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	82007
Description: Ø2.750 Support		Part Number:	D2894-1
Inspection Dwg: D2894	Rev: D	Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.454	0.474		.464	.464	.464	.457	.464
AB	3.062	3.082		3.072	3.072	3.072	3.072	3.072
AC	0.053	0.073		.063	.063	.063	.063	.063
AD	1.766	1.786		1.778	1.778	1.774	1.774	1.778
AE	0.020	0.040		.030	.030	.030	.030	.030
AF	0.260	0.267		.260	.260	.260	.260	.260
AG	0.170	0.190		.180	.180	.180	.180	.180
AH	0.150	0.170		.160	.160	.160	.160	.160
AI	1.990	2.010		1.998	1.995	2.000	1.994	1.995
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	1.880	1.900		1.892	1.892	1.897	1.896	1.892
AL	0.500	0.505		.502	.501	.500	.500	.500
AM	0.188	0.194		.188	.188	.188	.188	.188
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject				.000	.0015	.000	.001	.001

Measured by:	F.K.	Date:	12/04/19
Audited by:	<i>AK</i>	Date:	12/05/13
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	08.04.22	Reformat; Dwg Rev updated	KJ/DD	
E	08.11.25	Dimensions updated per Dwg Rev. D	KJ/JLM	
F	09.05.04	Dimension AN (0.926) removed	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	82007
<b>Description:</b> Ø2.750 Support		<b>Part Number:</b>	D2894-1
<b>Inspection Dwg:</b> D2894		<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	2	3	4	5
<b>HAAS Section</b>								
AA	0.454	0.474		.457				
AB	3.062	3.082		3.072				
AC	0.053	0.073		.062				
AD	1.766	1.786		1.779				
AE	0.020	0.040		.030				
AF	0.260	0.267		.260				
AG	0.170	0.190		.180				
AH	0.150	0.170		.160				
AI	1.990	2.010		2.000				
AJ	0.240	0.260		.250				
AK	1.880	1.900		1.892				
AL	0.500	0.505		.500				
AM	0.188	0.194		.188				
<b>Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"</b>								
<b>Accept/Reject</b>				, 06/				

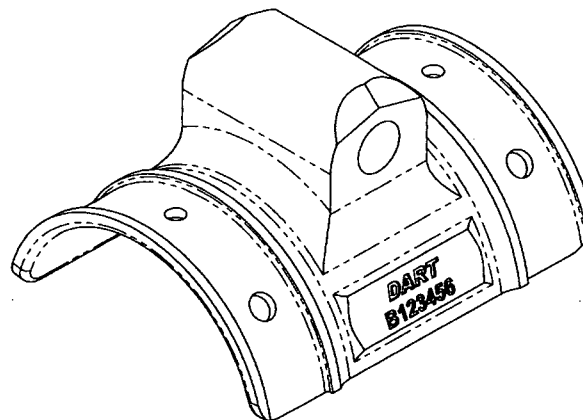
<b>Measured by:</b>	IFK	<b>Date:</b>	12/04/20
<b>Audited by:</b>	any	<b>Date:</b>	12/05/13
<b>Prototype Approval:</b>		<b>Date:</b>	

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E	08.11.25	Dimensions updated per Dwg Rev. D	KJ/JLM	
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RETURN TO  
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WITHOUT NOTICE  
WORK ORDER  
NO. 82007 MCT

12/03/21



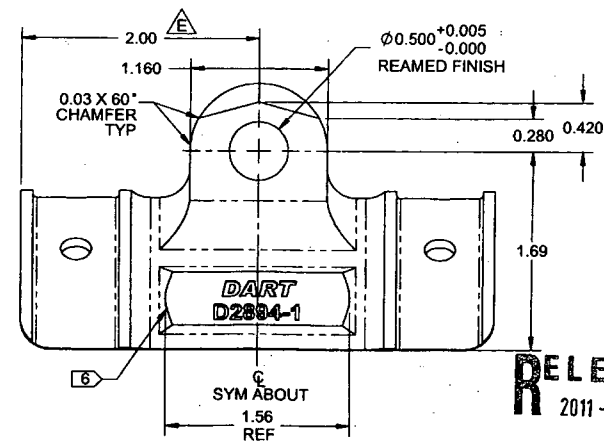
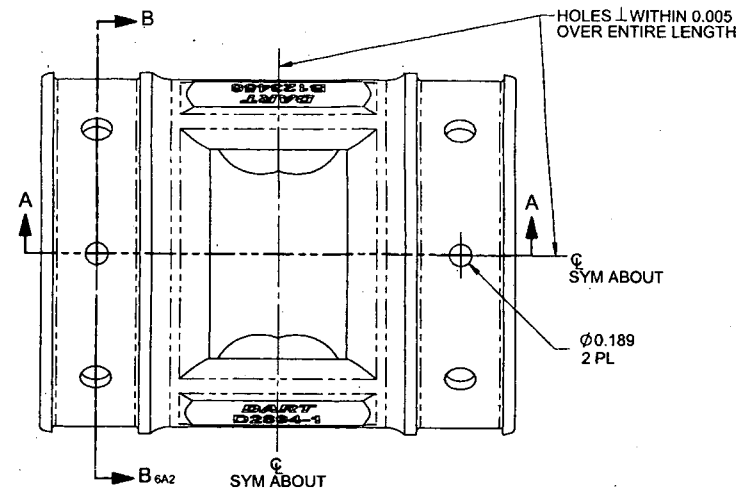
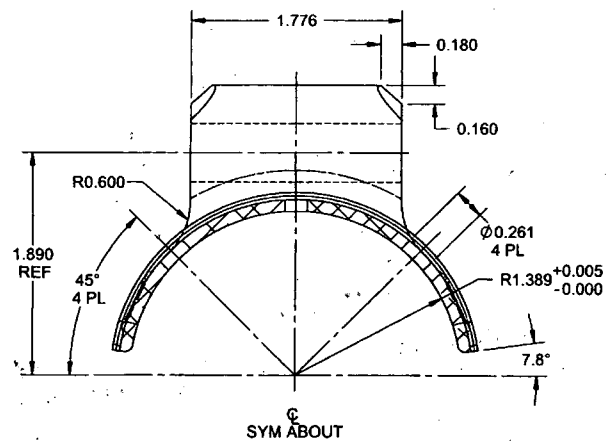
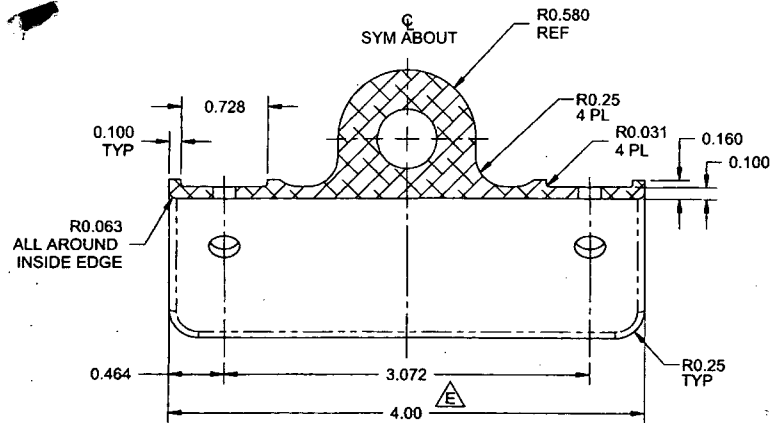
D2894-1 Ø2.750 SUPPORT

RELEASED  
2011-09-29  
JMP

**NOTES:**

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION  
PER ASTM A564 OR AMS 5643 OR AISI 630  
MIN UTS = 170 KSI (38 HRC)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) 0.50" WIDE x 1.56" LONG x 0.005" MIN HEIGHT FLAT,  
WITH R0.25 RADIUS OF TRANSITION IN THIS AREA  
IDENTIFY WITH DART LOGO AND PART NUMBER ON ONE  
SIDE AND DART LOGO AND BATCH NUMBER ON OPPOSITE  
SIDE USING 0.010-0.020 DEEP LETTERING
- 7) WEIGHT: 0.98 lbs

E	REMOVE PRIMER & UPDATE MAT'L SPEC (ZN A8-1), 2.00 WAS 2.000 (C3-2), 4.00 WAS 4.000 (C8-2), REF. CAR 11-51	CP	11.09.07
D	DRAWING REFORMATTED, POWDER COAT FINISH REMOVED, CHAMFERS ADDED TO TOP OF PART TO CLEAR ROCKER BEAM, PER BELL TECH BULLETIN 407-08-84, B5-2 0.261 HOLE WAS 0.257, B2-2 REAM FINISH INSTRUCTION ADDED.	AJS	08.11.06
C	ADD MASKING AND PRIME ONLY NOTES, REFORMATTED DRAWING.	DC	07.07.04
B	AS MANUFACTURED	CP	02.07.17
A	NEW ISSUE	CP	02.04.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.		<b>D2894</b>	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>Ø2.750 SUPPORT</b>	NTS
DATE	11.09.07	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



D2894-1 Ø2.750 SUPPORT

RELEASED  
2011-09-29  
JW

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	AS	D2894	SHEET 2 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	Ø2.750 SUPPORT	NTS
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